



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2353

Job Sheet 171399



Part No: D2353

Job Qty: 20 ea

Part Name: Stiffener



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 2/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP Rev: A Removed from 9 Digit 05-11-10 EC IPP: B 06.11.15 waterjet EC IPP: c 06.12.07 ecn 836 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	2/10/18	2/10/18	0.00	0.00	Start Up Waterjet		2/18/03/26
100	Waterjet	20 pcs	2/10/18	2/10/18	0.00	1.25	Waterjet1		2/18/03/26
120	QC	20 pcs	2/10/18	2/10/18	0.00	0.00	QC8		38
130	Brake NC	20 pcs	2/10/18	2/10/18	0.02	0.76	Brake NC 1		38
140	QC	20 pcs	2/10/18	2/10/18	0.00	0.00	QC5		38
150	HandFinish	20 pcs	2/10/18	2/10/18	0.00	0.84	HandFinish1		SA 18-04-04
155	QC	20 pcs	2/10/18	2/10/18	0.00	0.00	QC7		BR 18-4-4
160	Powdercoat	20 pcs	2/12/18	2/12/18	0.00	0.30	Powdercoat4		BR 18-4-4
170	QC	20 pcs	2/12/18	2/12/18	0.00	0.00	QC3		APR 04 2018
180	Packaging	20 pcs	2/12/18	2/12/18	0.00	0.00	Packaging3		APR 04 2018
190	QC21-SA	20 Ea	2/12/18	2/12/18	0.00	0.00	QC21		APR 04 2018

Part Op 100 - 1-Cut as per Dwg D2353

Descriptions: 130 - Bend per Dwg D2353

160 - START TIME:

12:06 CUT: 300° FINISH: 12:30

M 188700

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.9260 sf (.1463 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	3	105	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																															
Dart Aerospace Ltd. 1270 Aberdeen Street Hackensbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 03/26/18 Container No: S055001 Part: D2353 Job No: 171399 Serial No/Batch: S055001 Revision: Inspector:				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																															
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="3" style="text-align: left;">Other</th> </tr> <tr> <td style="width:15%;">Environment</td> <td style="width:15%;">☐</td> <td style="width:15%;">N</td> <td style="width:15%;"></td> <td style="width:15%;"></td> <td style="width:15%;"></td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Of</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Of</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Sup</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Trai</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td></td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td></td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td></td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td></td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td>OTHER :</td> <td></td> </tr> </table>						Root Cause			Other			Environment	☐	N				Design	☐	Of				Doc/Data	☐	Of				Equip/Tooling	☐	Sup				Handling/Pre	☐	Trai				Material	☐	Use				Internal Transport	☐	Poor Information	☐	Crushing		Tribal Knowledge	☐	Rushing	☐	Heat Treat		LOA	☐	Product Improvement	☐	Wave/Twist in Tube		Substation	☐	Process Improvement	☐	Marks/Chatter		Past Expiry Date	☐	Manufacturing Process	☐			Misidentified	☐	Past Due	☐	OTHER :	
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Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Stiffener	15.198inches $\pm$ 0.010	15.208 15.188	Special Comments
2	Stiffener	0.966inches $\pm$ 0.005	0.971 0.961	
3	Stiffener	0.354inches $\pm$ 0.010	0.364 0.344	
4	Stiffener	0.128inches $\pm$ 0.005	0.133 0.128	

Plex 3/26/18 8:59 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					